

Date: Tuesday, 10/06/2008 9:53:54 AM
 User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 39742
 Estimate Number : 10804
 P.O. Number :
 This Issue : 10/06/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SKIDTUBES
 Previous Run : 00015

Drawing Name : D350-636-014

Part Number : D350636014

Drawing Number : R08-052

Project Number :

Drawing Revision :

Material :

Due Date : 17/06/2008

Qty: 1 Um: Each

Written By :
 Checked & Approved By : JUD 08.10.10
 Comment :

Additional Product

Job Number:

**DART**

TRANSPORT CANADA APPROVAL # 09-89

TEL.: 1-613-632-3336
FAX: 1-613-632-4443

P/N	D350-636-014	CHG	CHG003
DESC.	Skidtube Assembly	STC	SH99-7
LOT	B38853	STC	SR00646SE
MODEL	AS350/355	STC	

US PATENT # 5735484
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

Seq. #: Machine Or Operation:

Description:

1.0 D350636014

Skidtube RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Skidtube RH
 Original B38853 @ CHG003

2.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Remove the following items and restock using the original batch#:

2x D3537-1 B37292 ✓

1x D3535-13 B37584 ✓

1x D3536-13 B36635 ✓

1x D3535-35 B36425 ✓

1x D3536-35 B38183 ✓

1x AN960C816L washer M104093 ✓

2x NAS1515H8L washer---Discard. ✓

Reassemble the skidtube as per DSI9413 Rev.A, and pick the following:

Sikaflex M: M1107893 A/R 08/10

Replace

(1x) MS21083-C87
 (2x) M107939

* PTO1 =>

JL 08-06-18 *L

JL 08-06-18 *L

4.0 D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Gasket B39421

JL 08-06-18 *L

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.06.18	3.0	DISCARD ALL FASTENERS & WASHERS (40X) AN3C-5A / M106574 (4X) AN3C-7A / M106906 (40X) AN960C-10H / M107321	HJ	08.06.18	①		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 9:53:54 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-014

Job Number: 39742

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D37931	Wearshoe
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39715

JSR

6.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39418

JSR

7.0	D37943	Gasket
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39422

JSR

8.0	D37933	Wearshoe
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39812

JSR

9.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

M108077

JSR

10.0	AN960C10L	washer
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

washer

M108077

JSR

11.0	D36721	Phenolic Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Phenolic Washer

B39275

JSR

12.0	AN526C1032R10	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M108062

JSR

08-06-18

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 9:53:54 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01. Dart Aerospace Ltd.

Drawing Name: D350-636-014

Job Number: 39742

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

13.0	AN526C1032R18	Screw
------	---------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Screw M108079

14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Apply LPS Procyon to all exposed hardware. M 104251 A/R

9/1 08-06-18 (X1)

15.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP
Put tube back with the original kit.

08/06/18 (X1)

16.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

New labels and paperwork required with the new batch # and most current change #.
Inspect kit, paperwork, and labels for completeness.

CH4604

17.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08/06/18 (X1)

18.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Repackage and return to stock.

Location:

Rev G

8/6/18

(X1)

50

19.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/06/2008

Job Completion



mf 08-06-18.

B 39742

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

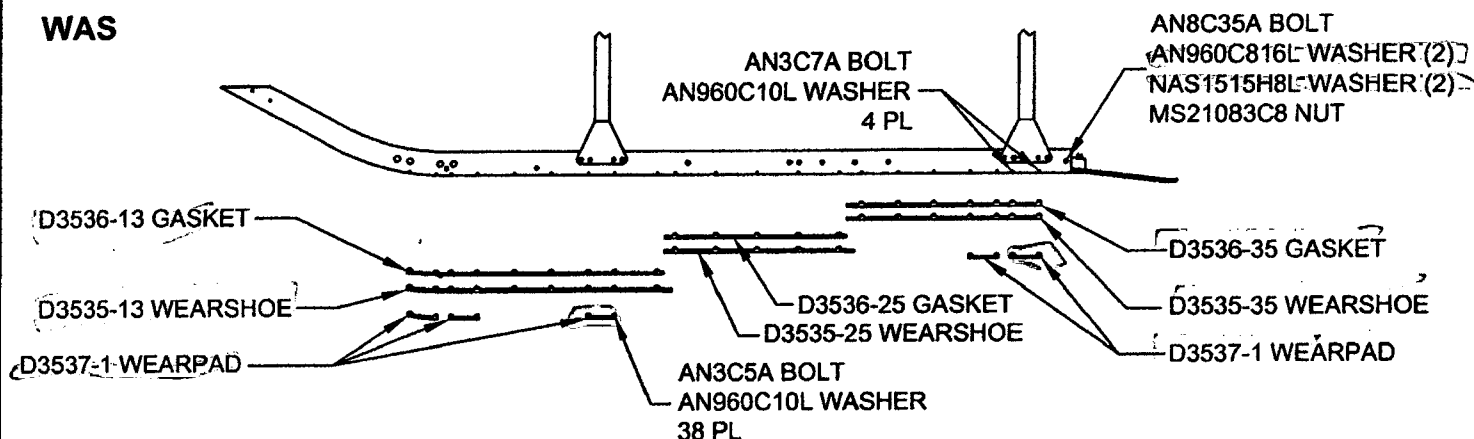
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

WAS



NOW

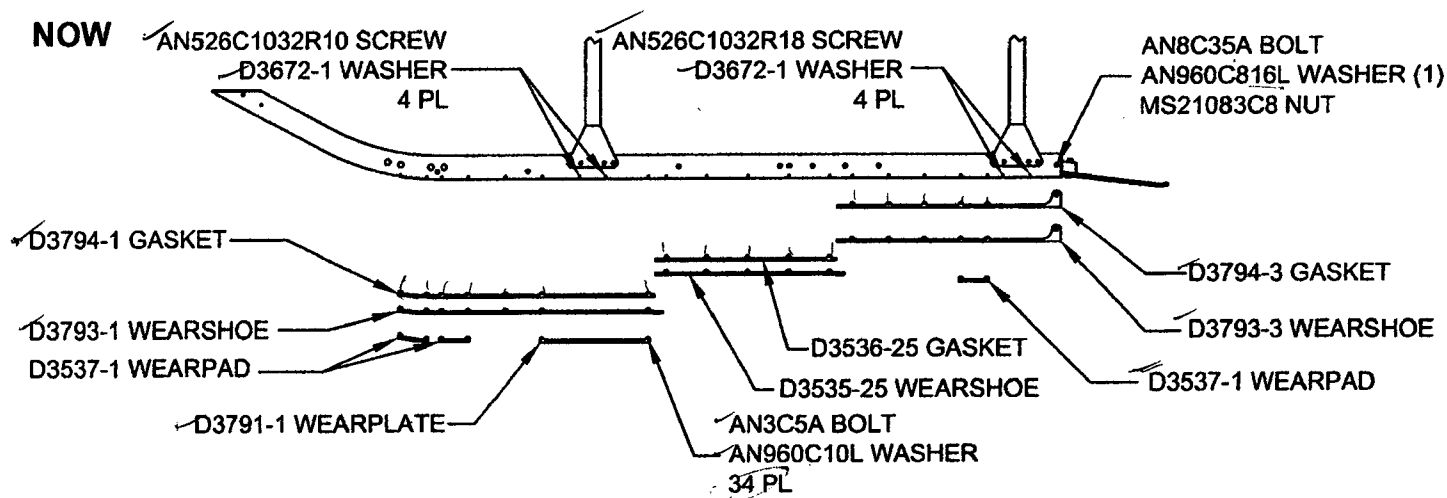


FIGURE 1 - WEARPLATE MODIFICATION

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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WORK ORDER
NO. 31142

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

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WORK ORDER
NO. 39742

DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE MODIFICATION	NTS
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TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. NOTE: SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

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NO. 39742

DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
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DART Aerospace Ltd

CUSTOMER RETURN

REFERENCE ONLY

#R08-052

Initiator: Jean Kerr
 Company: GCTPA
CGC 1001
 Phone No.: 262-798-580

Date: MAY 14/08
 Invoice # 6445
 Order Entry # 5969

Reason for return: NK08-043 - wearplates have interference with the Eurocopter SANDER
 Attach Copy of DHS Return Authorization # 415

Receiving: 8/6/0 Date Received: 8/6/0 Freight Company: MINI MAX Prepaid ☐ Collect ☐

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D350-636-013	38847	Skid tube LH	<u>DATE</u>	<u>8/6/6</u>
1	D350-636-014	38853	Skid tube RH		

Condition of packaging: GOOD Photograph required: yes ☐ no ☒

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC: Quarantine: Location: Condition of Part: good

Inspect: Initial: J

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D350-636-014	B38853	re-work & update tubes as per DSI 9413 Rev A, per W/O's.	<u>[Signature]</u>	39742	
1	D350-636-013	B38847			39751	

QA Coordinator: Advise GM as to findings: Initial: Date:

Comments:

Issue credit: yes ☐ no ☐
 GM Approval: Date:
 Invoice Amount:
 Less Replacement:
 Restock Fee:
 Freight:
 Net Credit:
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

Date: Tuesday, 10/06/2008 7:12:57 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 38735	Customer	: Dart Helicopters Services
Estimate Number	: 13104	DWG Name	: WEARSHOE KIT
Purchase Order #	:	Part Number	: D350636043
Complete Date	: 22/04/2008 3:40:19	DWG Number	: N/A
		Rev.	: E

DUE DATE	ORDERED	DELIVERED
23/04/2008	3	3

3.0 D35371-Wearpad	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	D35371	15.000	\$486.36	Lot # 37292 Qty. 15
Subtotal:	QTD:	0 CTD:	15	\$486.36	Qty 1

4.0 D353513-Wearshoe	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	D353513	3.000	\$27.02	Lot # 37584 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$27.02	

5.0 D353613-Gasket	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	D353613	3.000	\$12.27	Lot # 36635 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$12.27	

6.0 D353525-Wearshoe	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	FAUT01: Fauteux, Melanie	D353525	3.000	\$42.40	Lot # 38162 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$42.40	

7.0 D353625-Gasket	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	D353625	3.000	\$7.86	Lot # 36636 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$7.86	

8.0 D353535-Wearshoe	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	D353535	3.000	\$41.38	Lot # 36425 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$41.38	

9.0 D353635-Gasket	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	D353635	3.000	\$5.16	Lot # 38183 Qty. 3
Subtotal:	QTD:	0 CTD:	3	\$5.16	

10.0 AN3C5A-Bolt	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	AN3C5A	114.000	\$40.47	Lot # 106574 Qty. 114
Subtotal:	QTD:	0 CTD:	114	\$40.47	

11.0 AN3C7A-BOLT	INVENTORY ITEM				
DATE	EMPLOYEE	TYPE	Qty	COST	
22/04/2008	DESJ02: Desjardins, Line	AN3C7A	12.000	\$4.81	Lot # 105906 Qty. 12
Subtotal:	QTD:	0 CTD:	12	\$4.81	

Date: Tuesday, 10/06/2008 7:12:57 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 38735	Customer	: Dart Helicopters Services
Estimate Number	: 13104	DWG Name	: WEARSHOE KIT
Purchase Order #	:	Part Number	: D350636043
Complete Date	: 22/04/2008 3:40:19	DWG Number	: N/A
		Rev.	: E

12.0 AN960C10L-washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
22/04/2008	DESJ02: Desjardins, Line	AN960C10L	126.000		\$7.49	Lot # 107321 Qty. 126

Subtotal: QTD: 0 CTD: 126 \$7.49

		TIME	COST
	Machine Time:	0.00	\$0.00
	Labor:	0.00	\$0.00
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$675.22
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$675.22

COST PER UNIT: \$225.07